

Date: Tuesday, 11/22/2005 4:58:47 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 24942	
Estimate Number : 10310	
P.O. Number : N/A	Part Number : D26175
This Issue : 11/22/2005 S.O. No. : N/A	Drawing Number : D2617 REV D2
Prsht Rev. : NC	Project Number : N/A
First Issue : 11/22/2005 Type : MACHINED PARTS	Drawing Revision : D2
Previous Run : 24401	Material : N/A
Written By : <u>See comment below</u>	Due Date : 12/2/2005 Qty: 60 Um: Each
Checked & Approved By : <u>See comment below</u>	
Comment : Est H 04.07.14 Reformat; added step 5 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M6061T6T0500W058	6061-T6 Tube .500 x.058W
-----	------------------	--------------------------



Comment: Qty.: 0.0205 f(s)/Unit Total : 1.2285 f(s)

6061-T6 Round Bar 1.5"

Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6)

Ø0.500" tubing x 0.058" wall

M6061T6T0.500W.058)

Batch M17267

QML 05/11/27

60

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL

Machine as per Folio FA438 and Dwg D2617

Ø0.500" tubing x 0.058" wall

QML 05/11/27

60

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QML 05/11/27

60

4.0	QC8	SECOND CHECK <u>5.1</u>
-----	-----	-------------------------



Comment: SECOND CHECK

SAD 05/11/27

60

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------




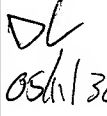

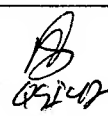
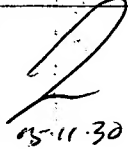
Comment: Deburr break all unmarked sharp edges 0.005 to 0.010

DL 05/11/30

59

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DP Date: 05/12/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05-11-30	5	1 part deburred to much on the side		scrap - destroy	 05/11/30	 05-11-30		 05-11-30

NOTE: Date & initial all entries

Date: Tuesday, 5/22/2005 4:58:47 PM

User: Linda B

Process Sheet

Customer: CUBA 001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 24942

Part Number: D26175

Job Number:



Seq. #:

Machine Or Operation:

Description :

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

M/ 05/12/01 59

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

DC 05/11/30 59

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

05/12/01 59

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 49

10 5/12/01 59

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 05/12/05 59

05/12/02

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

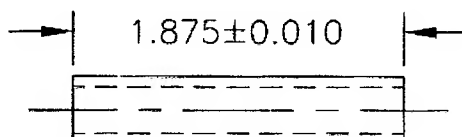
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

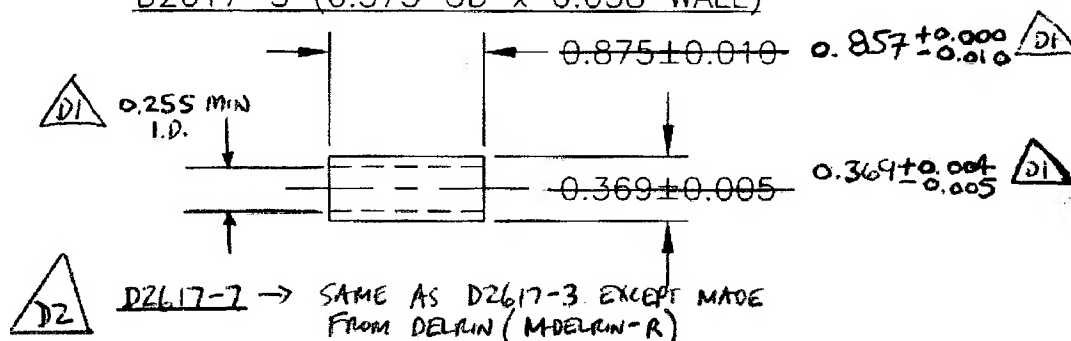


DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE	01.07.04			TITLE BUSHING	SCALE 1:1
DZ	04.09.10	CP	ADD D2617-7	A	96.10.08 NEW ISSUE
				B	97.05.08 .875 WAS 1.125
				C	97.06.04 0.369 DIA WAS 0.375
				D	01.07.04 ADD MAT'L SPEC AND TOL./DIM. NOTE
				D1	CP 04.07.12 CORRECT TOLERANCE (NCR 779)

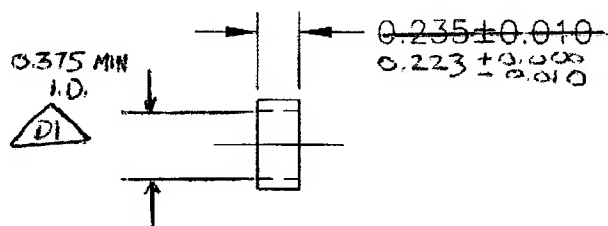
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

Copyright © 1996 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

